

Work Order ID 64885



Page 1

December 21, 2010 1:08:59 PM

Item ID: D3196-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-12-2 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3196	Rev C								

100
 BAND SAW
 Bandsaw
 Memo
 Jeaspa Bandsaw
 Cut blank: (0.75" x 1.50") x 34.750" long Bar

0.00

0.00

S.A 11/01/17

4

0

110
 HAAS CNC VERTICAL MACHINING #1
 HAAS I
 Memo
 HAAS CNC vertical machine #1
 1-Machine D3196-3 as per Folio FA339 and Dwg D3196-3 2-
 Deburr

0.00

0.00

SL 11/01/17 (4)

120
 QC2- Inspect parts off machine FAI/FAIB
 QC
 Memo
 Quality Control

0.00

0.00

SL 11/01/17

Work Order ID 64885

December 21, 2010 1:09:00 PM



Page 2

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



11/01/18

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



11/01/18

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



11/25/18

Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:15

OVEN TEMPERATURE:

FINISH TIME:

8:45

4. 11-01-19.

Work Order ID 64885

December 21, 2010 1:09:00 PM



Page 3

Item ID: D3196-3

Accept



Setup Start



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Item Name: Bar

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

⇒ JH

11/01/19

X4

0

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 260

0.00

Packaging

Memo

0.00

Packaging

11/01/19 (4)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/19

ME
11-01-19

Picklist Print

December 21, 2010 1:08:59 PM

Page 1

Work Order ID: 64885

Parent Item: D3196-3

Parent Item Name: Bar



Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	32.5460	2.89	12.16842			



6061-T6 Bar .750 X 1.50



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	29.546	
116135	1.746	
116405	27.8	
MAT028	3	
114968	3	

116604

12.1684^{ft} H.A 11/01/17

DART AEROSPACE LTD		Work Order: 64885
Description: Bar		Part Number: D3196-3
Inspection Dwg: D3196	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	✓		m-tape	
33.650	+/-0.005	33.650	✓			
0.488	+/-0.005	.490	✓		vern. 2L-3	
17.011	+/-0.010	17.011	✓			
0.512	+/-0.005	.512	✓			
1.500	+/-0.010	1.501	✓			
0.464	+/-0.010	.463	✓			
0.504	+/-0.010	.503	✓			
Ø0.344	+0.006/-0.001	.344	✓			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	.660x100°	✓			
0.962	+/-0.005	.962	✓			
0.750	+/-0.010	.750	✓			
4.750	+/-0.010	4.750	✓			
12.531	+/-0.010	12.531	✓			
16.999	+/-0.010	16.999	✓		m-tape	
21.844	+/-0.010	21.844	✓		m-tape	
29.625	+/-0.010	29.625	✓		m-tape	
0.250	+/-0.010	.252	✓			
1.000	+/-0.010	1.001	✓			
R0.125	+/-0.010	.125	✓		R-G	
0.987	+/-0.010	.989	✓			
0.060 x 45°	+/-0.010 x 0.5°	.060x45°	✓			

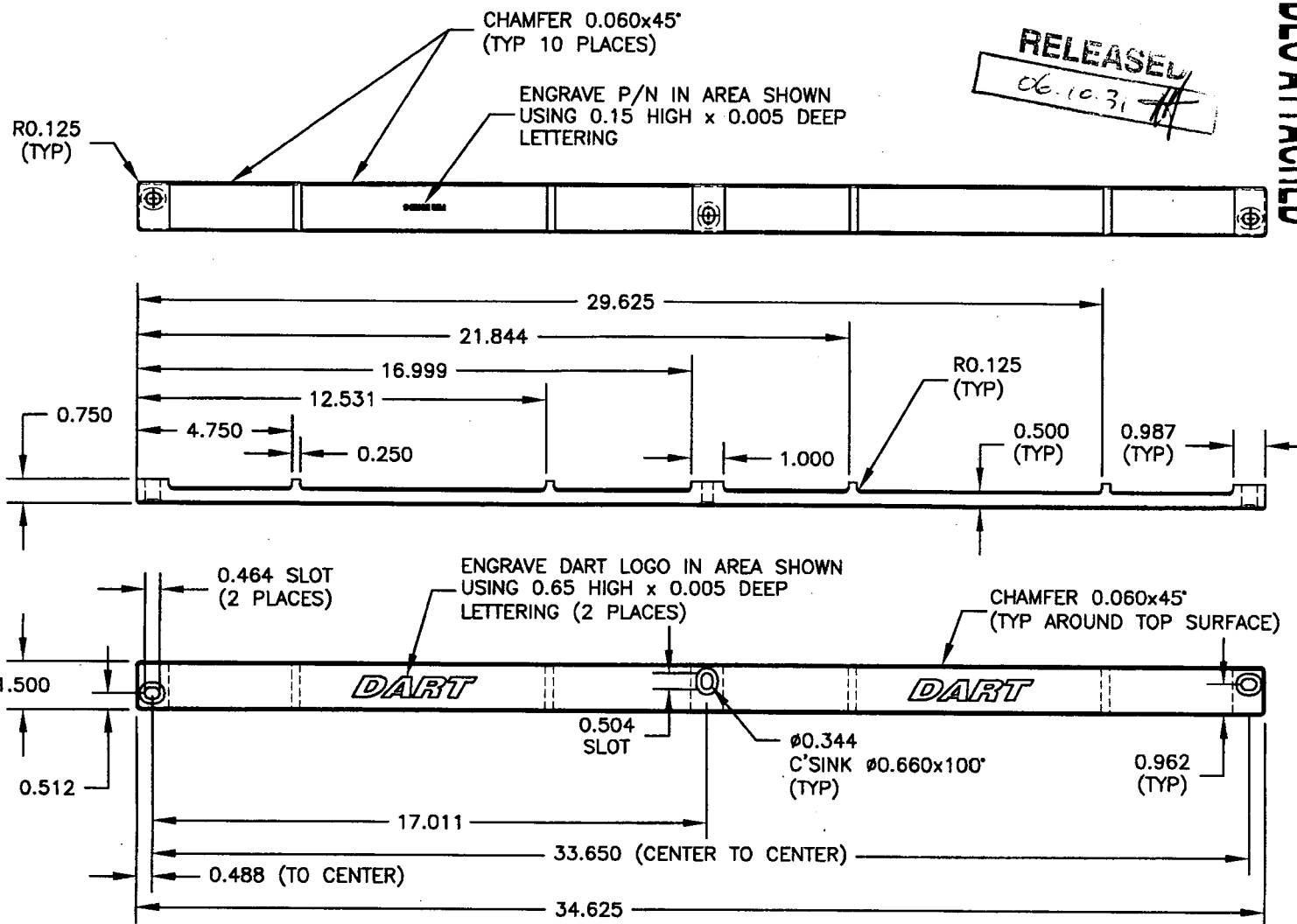
Measured by: JH	Audited by: ml	Prototype Approval:	N/A
Date: 11/01/17	Date: 11/01/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	



DEO ATTACHED

RELEASED
06.10.31



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

#64885

DESIGN	APPROVED	DRAWING NO.	REV. C
CHECKED	APPROVED	D3196	SHEET 2 OF 3
DATE	TITLE	SCALE	
06.10.31	BAR	1:5	

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA